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2 **Claims**

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5 We claim:

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8 1. A foundry binder system, which will cure in the presence of sulfur dioxide and

9 an oxidizing agent, comprising:

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12 (a) 40 to 80 parts by weight of an epoxy resin;

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14 (b) 1 to 40 parts of an ester of a fatty acid;

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16 (c) 1 to 10 parts of an alkyl silicate;

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18 (d) an effective amount of an oxidizing agent; and

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20 (e) 0 parts of an ethylenically unsaturated monomer or polymer.

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22 wherein (a), (b), (c), and (d) are separate components or mixed with another of

23 said components, and where said parts by weight are based upon 100 parts of

24 binder.

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27 2. The binder system of claim 2 wherein the wherein the epoxy resin is selected

28 from the group consisting of epoxy resins derived from bisphenol A, epoxy

29 resins derived from bisphenol F, epoxidized novolac resins, cycloaliphatic epoxy

30 resins, and mixtures thereof.

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32 3. The binder system of claim 2 wherein the epoxy resin has an epoxide equivalent

33 weight of about 165 to about 225 grams per equivalent.

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1       4. The foundry binder system of claim 3 which further comprises a polyol selected  
2                   from the group consisting of phenolic resole resins, polyester polyols, and  
3                   polyether polyols.

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5       5. The binder system of claim 4 wherein the oxidizing agent is cumene  
6                   hydroperoxide.

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8       6. The foundry binder system of claim 5 wherein the amount of epoxy resin is  
9                   from 50 to 70 parts by weight, the amount of ester of a fatty acid is from 15 to  
10                  30 parts by weight, the amount of alkyl silicate is from 2 to 8, and the amount of  
11                  amount of a oxidizing agent is from 12 to 30 parts by weight, where the weights  
12                  are based upon 100 parts of the binder system.

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14       7. A foundry mix comprising:

15           (a) a major amount of foundry aggregate;

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17           (b) an effective bonding amount of the foundry binder system of claim 1, 2,  
18                  3, 4, 5, or 6.

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20       8. A cold-box process for preparing a foundry shape comprising:

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22           (a) introducing the foundry mix of claim 7 into a pattern; and

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24           (b) curing with gaseous sulfur dioxide.

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26       9. A foundry shape prepared in accordance with claim 8.

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28       10. A process of casting a metal article comprising:

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1 (a) fabricating an foundry shape in accordance with claim 8;  
2 (b) pouring said metal while in the liquid state into said foundry shape;  
3 (c) allowing said metal to cool and solidify; and  
4 (d) then separating the molded article.

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6 11. A casting prepared in accordance with claim 10.

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